

Ship ASAP

Dart Aerospace Ltd.

8/24/08

Date: Wednesday, 1/23/2008 11:31:02 AM
User: Kim Johnston

Process Sheet

8/24/08

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 36909 -2	
Estimate Number : 10145	
P.O. Number :	Part Number : D2037101
This Issue : 1/23/2008 S.O. No. :	Drawing Number : D2037 REV C3
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL / MED FAB	Drawing Revision : C3
Previous Run : 36886C	Material :
Written By :	Due Date : 2/1/2008 Qty: 4 Um: Each
Checked & Approved By : <u>HA 080123</u>	
Comment : Est Rev:A New Issue 05-11-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 4.1118 f(s)/Unit Total: 41.1180 f(s)

M106956 x 12

= 49.3416

Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049)

Batch: B106015 x 3 / 105988 x 3

FF 08-01-24

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

FF 08-02-04

1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1

FF 08-01-24

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037

2-Flatten ends of D2037-101 tube as required using DT8545

3-Deburr as required

EP 08/02/04 (12)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/02/07 (12)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WHT

08-02-07

11/10/

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 36909

Part Number: D2037101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

08/02/08 7D

Completion



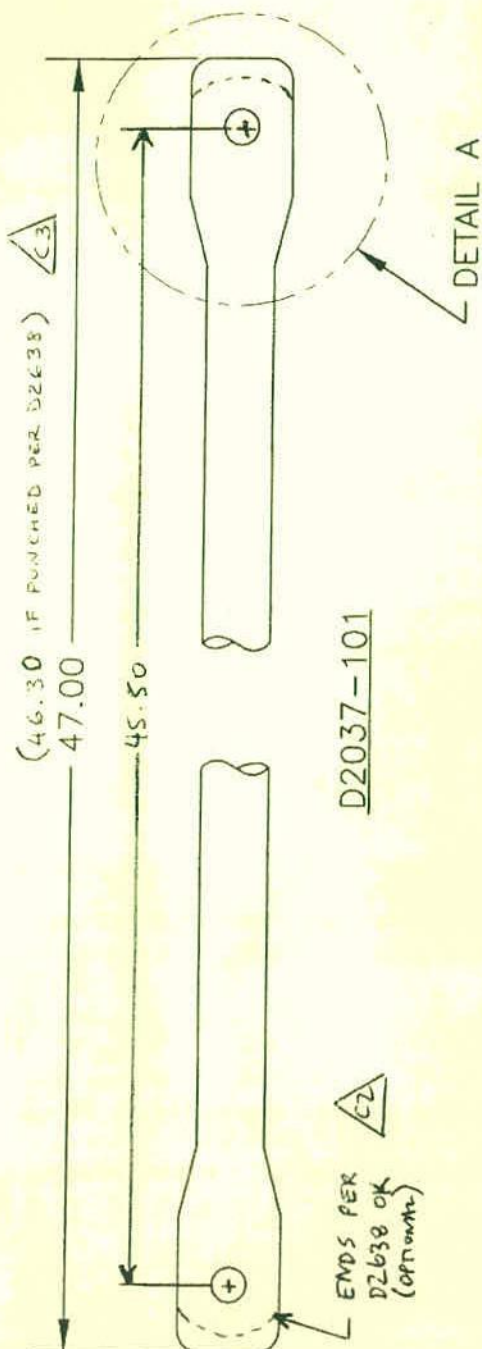
2008/2/08

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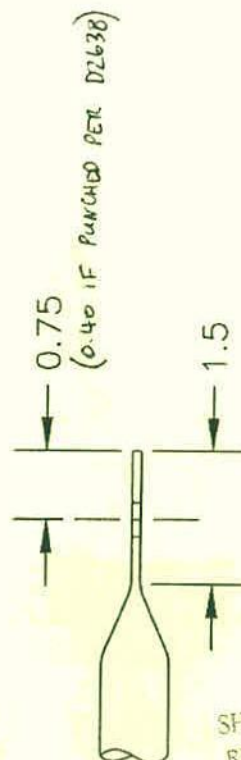
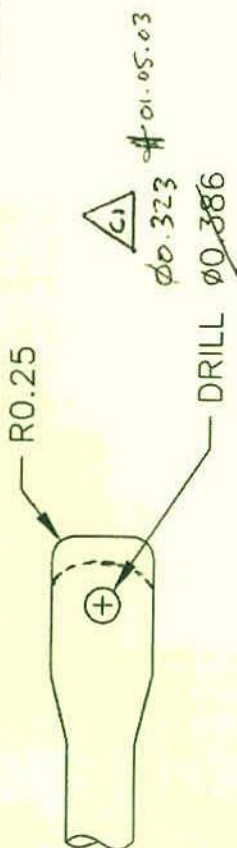
(12)

DART

DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2037	REV. C SHEET 1 OF 1
DATE 99.06.07	TITLE ARM	SCALE NTS	
A	91.10.22	NEW ISSUE	
B	93.04.20	-103 DELETED	
C	99.06.07	REDRAWN, 0.386 WAS 0.375	
C1	# IP 01.05.03	CHANGE TO $\phi 0.323$	
C2	# IP 02.06.14	ADD PUNCH PER D2638 AS OPTION	



D2037-101

**RELEASED**
KE 99.06.10

DETAIL A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36909

MATERIAL: AISI 304/316 SS SEAMLESS TUBE, 0.750 O.D. x 0.049 WALL

C3 # 05.04.27 ADD 46.30 PUNCHED PER D2638

